

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000743**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 08-May-2008**Location:** Changxing Island, Shanghai, PRC

Submittals(New / Total): **CWR's:** / **HSR's:** / **NCR's:** /

Item	Title	Detail
1	Key conversations	<p>ISMR met with Caltrans Senior Bridge Engineer Scott Kennedy and ABF Engineer Dan Raynor to discuss Tower partial mockup status. Mr. Raynor requested that TL-08-1055, rejecting ZPMC's partial mockup procedure, be resubmitted with detailed comments for revision. ISMR revised TL-08-1055 to Revision 1 and submitted to Construction for approval.</p> <p>Mr. Raynor stated that ZPMC was still practicing the partial mockup 15mm fillet welds, but that they now had four out of ten welds that had cracked and that the only welds that had cracked were the lug plate to diaphragm plates. Mr. Raynor also stated that the welds were inspected immediately after welding and no cracks were apparent, but that several days later the cracks appeared. ISMR pointed out that the diaphragm plates are HPS485 material and the Contract Special Provisions require H4 electrodes to be used when welding to HPS485 material in order to prevent hydrogen-cracking. ISMR pointed out that the delayed appearance of cracks is a symptom of hydrogen induced cracking. ISMR also pointed out that WPS's that had been provided by ABF did not specify H4 electrodes. ISMR inquired whether ZPMC was using H4 electrodes. Mr. Raynor stated that he was sure that ABF had confirmed in the past that ZPMC was using H4 electrodes.</p>
2	Other important observations	Caltrans inspector observed that ZPMC has started to fit-up and weld diaphragm flange plates.

Inspected By: McReynolds,Robert

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer